

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: 206 A/B HIGH GEAR WEB		
<b>Job Number</b>	: 30724				
<b>Estimate Number</b>	: 10455				
<b>P.O. Number</b>	: N/A	<b>Part Number</b>	: D26543		
<b>This Issue</b>	: 2/9/2007	<b>S.O. No.</b>	: N/A	<b>Drawing Number</b>	: D2654 REV E1
<b>Prsht Rev.</b>	: NC			<b>Project Number</b>	: N/A
<b>First Issue</b>	: N/A	<b>Type</b>	: LANDING GEAR	<b>Drawing Revision</b>	: E1
<b>Previous Run</b>	: 30723			<b>Material</b>	: N/A
<b>Written By</b>	: _____	<b>Due Date</b>	: 2/16/2007	<b>Qty:</b>	5 Um: Each
<b>Checked &amp; Approved By</b>	: _____				
<b>Comment</b>	: Est Rev: 99.02.04 Fixed typo, Changed procedureDM				

## Job Number:



1.0	D26005108	Extrusion 'I Beam' thin
-----	-----------	-------------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit    Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D2600-5	Web

Batch

Batch B24410 \* / JB 7-2-12

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



**Comment:** LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2654

2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

#### 4-Deburr holes and ends

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



**Comment:** INSPECT WORK TO CURRENT STEP

RF 07-02-12 (5)

4.0 HAND FINISHING1 . . . . . HAND FINISHING RESOURCE #1



**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Amc / 5D 7-2-12

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 19 Date: 07/02/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Friday, 2/9/2007 10:18:17 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 30724

Part Number: D26543

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 7-2-13

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 4/6

DP 7-2-13

(5)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(5)  
DP 07/02/14

Job Completion



U 07/02/14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

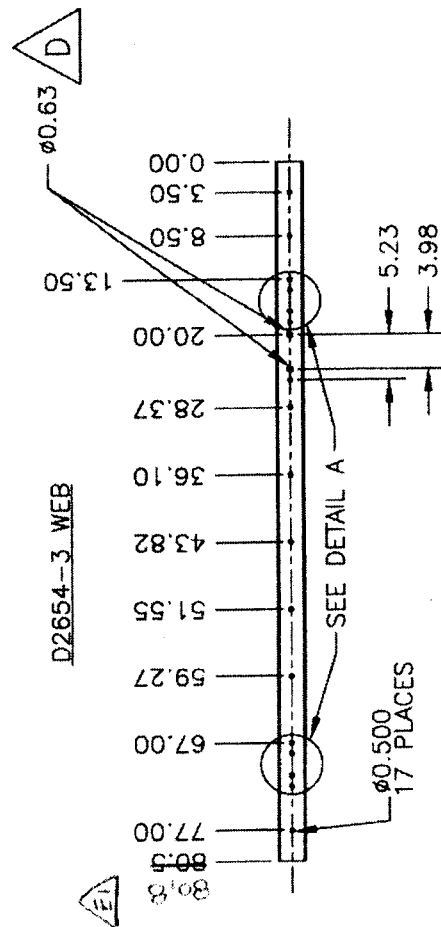
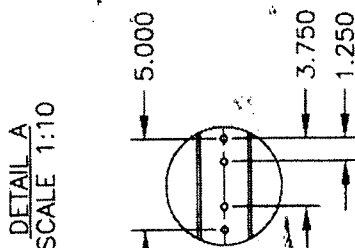
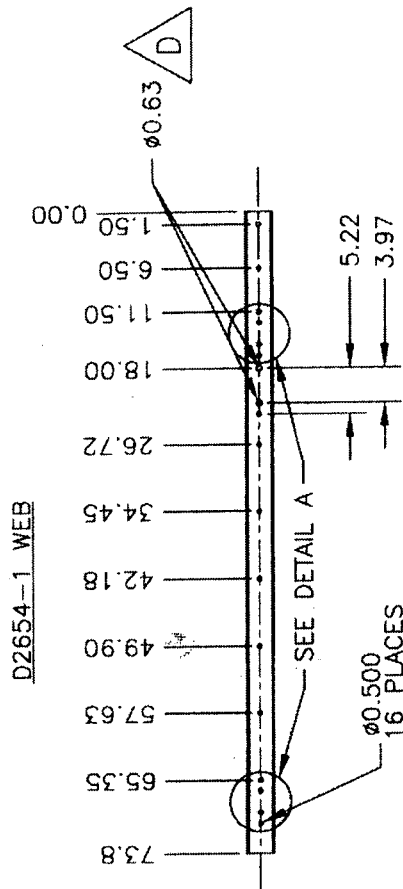
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE USA, INC.	REV. E
				PORT HADLOCK, WA	
CHECKED	<i>#</i>	APPROVED	<i>#</i>	DRAWING NO. D2654	SHEET 1 OF 2
DATE	04.05.26	TITLE	WEB	SCALE	1:20
A	97.03.25	NEW ISSUE			
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438			
C	97.10.29	CHANGED HOLE PATTERN			
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$			
E	04.05.26	CHANGE LENGTHS, REFORMAT			
E1	<i>CP</i> 04.08.04	PER TOOLING; 90.8 WAS 90.5			

RELEASED  
04.06.22



MAKE FROM D2600-5-108 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

C207102109  
W10 30724

